

Page 1

JUL 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 132377

132377

Page 2

May-07-15 2:35:02 PM

Item ID: D412-698-013 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Door Handle -Aluminum Door
 Start Date: 5/01/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							DAS 02 3-89
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-013 Location: <u>FC 022</u>								JUL 14 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MLJ JUL 14 2015
Quality Control									

MLJ JUL 14 2015

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Picklist Print

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Page 1

Work Order ID: 132377

132377

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 5/01/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3203-1		Manufactured	No				Each	33.0000	4	8			
D3203-1 Handle													
DAS 02 9-89													
Location ST483													
Loc Qty 33													
Loc Code 27221 130880 131741													
1 7 J.A													
27 9-89													

D3220-041		Manufactured	No				Each	6.0000	2	2			
D3220-041 Doubler Assembly													
DAS 02 9-89													
Location ST484													
Loc Qty 6													
Loc Code 117212 131978													
2 J.A													
27 9-89													

D3220-042		Manufactured	No				Each	5.0000	2	2			
D3220-042 Doubler Assembly													
DAS 02 9-89													
Location ST484													
Loc Qty 5													
Loc Code 112411 126282													
2 J.A JUL 08 2015													
27 9-89													

133954

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID: 132377

132377

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 5/01/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

D3220-3

Manufactured No

Each 10.0000 **2** 4

D3220-3

Doubler

DAS
02
9-89

Location

Loc Qty

Loc Code

DAS
27
9-89

ST485

10

130481

10

MS21042L4

Purchased No

~~13~~ 133086

Each 2,297.000

****** **8** **4** 16

J.A

MS21042L 4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

DAS
27
9-89

FP001

42

m124231

42

GA

224

m127813

224

ST260a

62

m130799

56

m131803

6

ST305

1969

m128300

8

m130388

16

m130922

97

m131618

12

m132123

1836

MS24694-S98

Purchased No

M132262

Each 84.0000

****** **16** **16** 32

J.A

MS24694-S98

Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

DAS
27
9-89

ST288

84

m128606

1

m131957

83

32

J.A JUL 08 2015

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Shop Packet Print

Page 2

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
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Work Order ID: 132377

132377

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 5/01/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0416J

Purchased

No

Each

4,886.000

8

16

NAS1149D0416.J

**

DAS

WASHER

27

9-88

DAS
02
9-89

Location

Loc Qty

Loc Code

ST270

4886

m131511

4886

16

J.A

JUL 08 2015

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01